

Date: Friday, 11/04/2008 4:32:25 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	212/205 HIGH FED X-TUBE ASSEMBLY
<b>Job Number</b> :	38572		
<b>Estimate Number</b> :	10254		
<b>P.O. Number</b> :		<b>Part Number</b> :	D212664101
<b>This Issue</b> :	11/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D212-664-141 REV C
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38571	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	LANDING GEAR	<b>Due Date</b> :	21/04/2008
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	JLD 08.4.011	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:E 04.02.16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG003

08/05/14 8.4.22 JLD

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

3.0	D212664101TRN	CROSSTUBE TURNING DETAIL
-----	---------------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B38616

17 8-5-5

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

17 8-5-5

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------



Comment: DIMENSIONAL CHECK OF X-TUBES

08/05/14 (21)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 4:32:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 38572

Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

EL  
8-5-6  
8-5-7 AWM

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

AWM  
4-5-7

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/07 (XL)

9.0	OUTSIDE SERV.10	OUTSIDE SERVICES -skids
-----	-----------------	-------------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 6341

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C 208/05/11 20

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

C 8/5/9

11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

5 08/05/12 (XL)

12.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

m 08 05 12 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/04/2008 4:32:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 38572

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

2-Paint outside crosstube with White Imron as per QSI 005 4.2 ml 08 05 12 ①

13.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

RT 08-05-13

14.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1

Support

38123

ml 08 05 13

15.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.2000 Each(s)/Unit Total : 4.2000 Each(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: 38618

ml 08 05 13

16.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25

Clamp

107973

ml 08 05 13

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015. Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch:

107621

Expiry Date: 08/2009 Time: 12:00pm

3-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 08 05 14 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/04/2008 4:32:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 38572

Part Number: D212664101

Job Number:



Seq. #: Machine Or Operation: Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 00/05/14 PL*

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

20.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
PLACARD  
Batch: *B37058*

21.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: *M107178*

22.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: *M107534*

23.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)  
Washer  
Batch: *M106552*

24.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Nut  
Batch: *M105077*

*PL 8/0/14 PL*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 11/04/2008 4:32:25 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 38572

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*08/05/14* (signature)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

*REV D*

*28/07/14* (signature)

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/05/16* (signature)

Job Completion



*MF 08-05-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38572
<b>Description:</b> Crosstube Assembly (205/212/412 High Fwd)	<b>Part Number:</b> D212-664-141
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

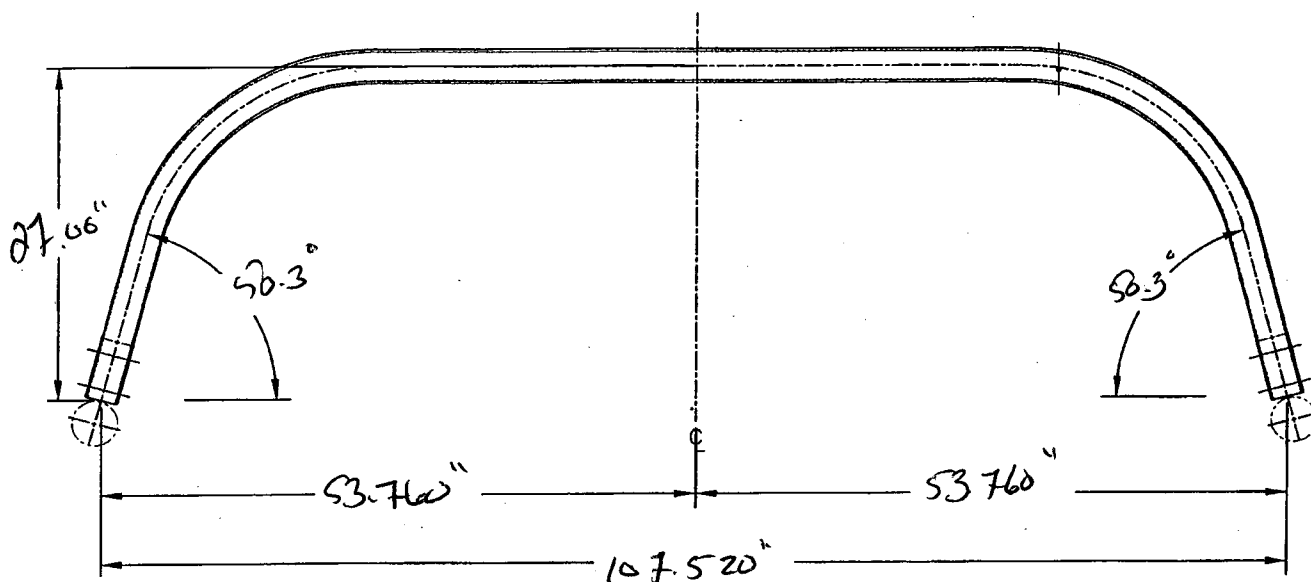
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010					
	R0.063	+/-0.010					
	2.740	+0.005/-0.000					
	5.097	+/-0.030					
	2.304	+0.005/-0.000					
	2.340	+0.005/-0.000					
	2.398	+0.005/-0.000					
	2.448	+0.005/-0.000					
	2.498	+0.005/-0.000					
	2.549	+0.005/-0.000					
	2.599	+0.005/-0.000					
	2.671	+0.005/-0.000					
	2.701	+0.005/-0.000					
SIDE B	0.200	+/-0.010					
	R0.063	+/-0.010					
	2.740	+0.005/-0.000					
	5.097	+/-0.030					
	2.304	+0.005/-0.000					
	2.340	+0.005/-0.000					
	2.398	+0.005/-0.000					
	2.448	+0.005/-0.000					
	2.498	+0.005/-0.000					
	2.549	+0.005/-0.000					
	2.599	+0.005/-0.000					
	2.671	+0.005/-0.000					
	2.701	+0.005/-0.000					
	126.51	+/-0.020					

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38572
<b>Description:</b> Crosstube High Fwd (205/212/412)		<b>Part Number:</b> D212-664-101
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	
Date	08/05/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	



DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>GP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED  
07.04.24 **[Signature]**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **38572**



# LIQUID PENETRANT TEST REPORT

P - 1273 1

CLIENT	DART AEROSPACE	DATE	MAY 9, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB No.	188 08 1273	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/VO No.					
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	407 FWD X TUBE, 212/205 HIGH FED/AFT X TUBE						
ITEM(S) EXAMINED	JOB #S 212/205-38572, 38843, 38844, 407-38989						

JOB DESCRIPTION	PROCEDURE No. LT-0002	REV./DATE	TECHNIQUE No. LT-TECH2	REV./DATE
PART No. D212664101/D212664201/D407667105.		MATERIAL ALODINED ALUM.		THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE				

## TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup>	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 1 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

## TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

## RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION  
CARRIED OUT ON 100% EXTERNAL  
SURFACE ON:  
212/205 HIGH FED X TUBE JOB#: 38572  
212/205 HIGH AFT X TUBE JOB#: 38843,38844.  
407 FWD X TUBE JOB#: 38989.

RESULTS: NO INDICATION OF DEFECTS.  
ITEMS ACCEPTABLE TO STANDARD

**Scope of Services**  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

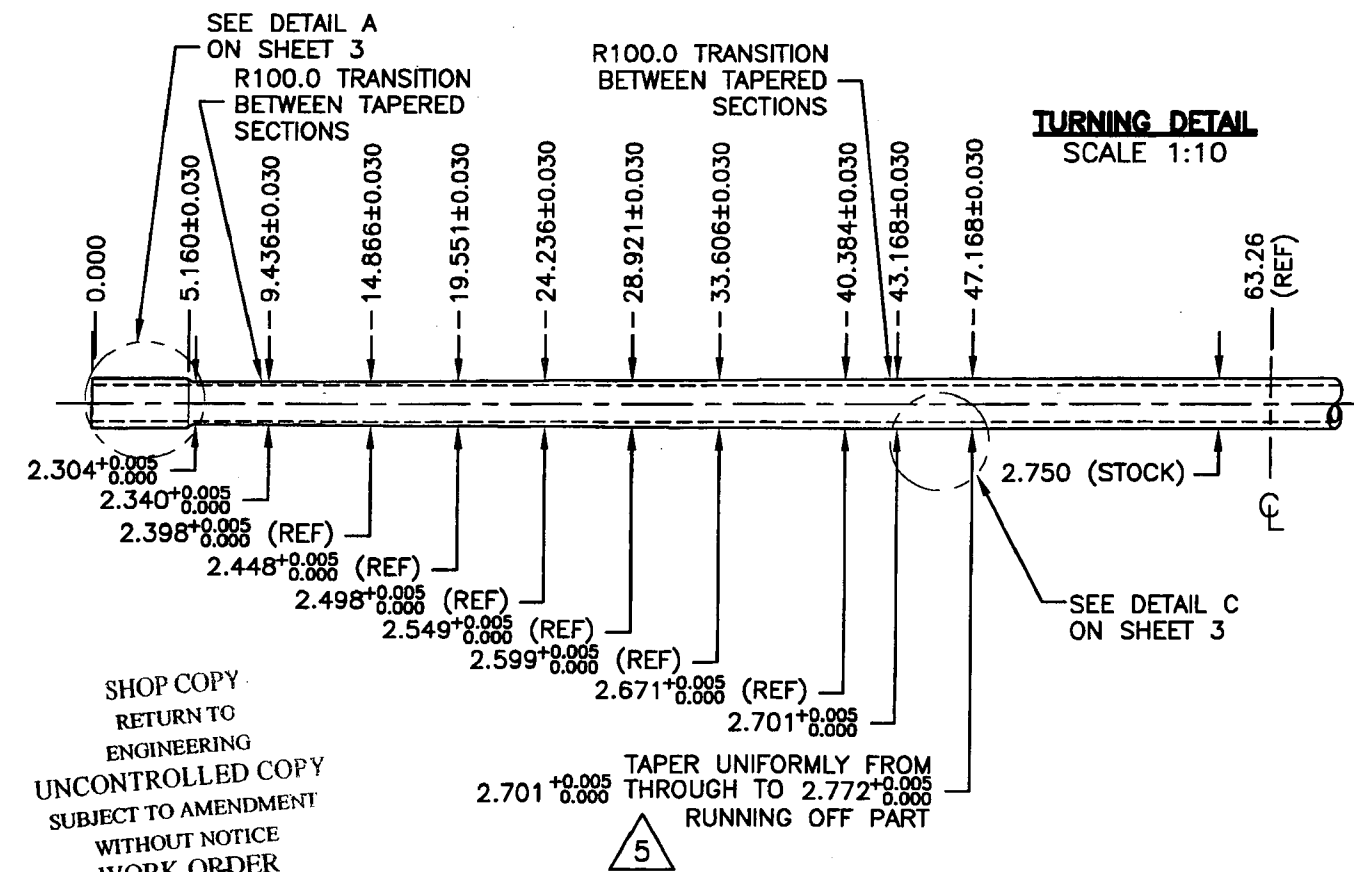
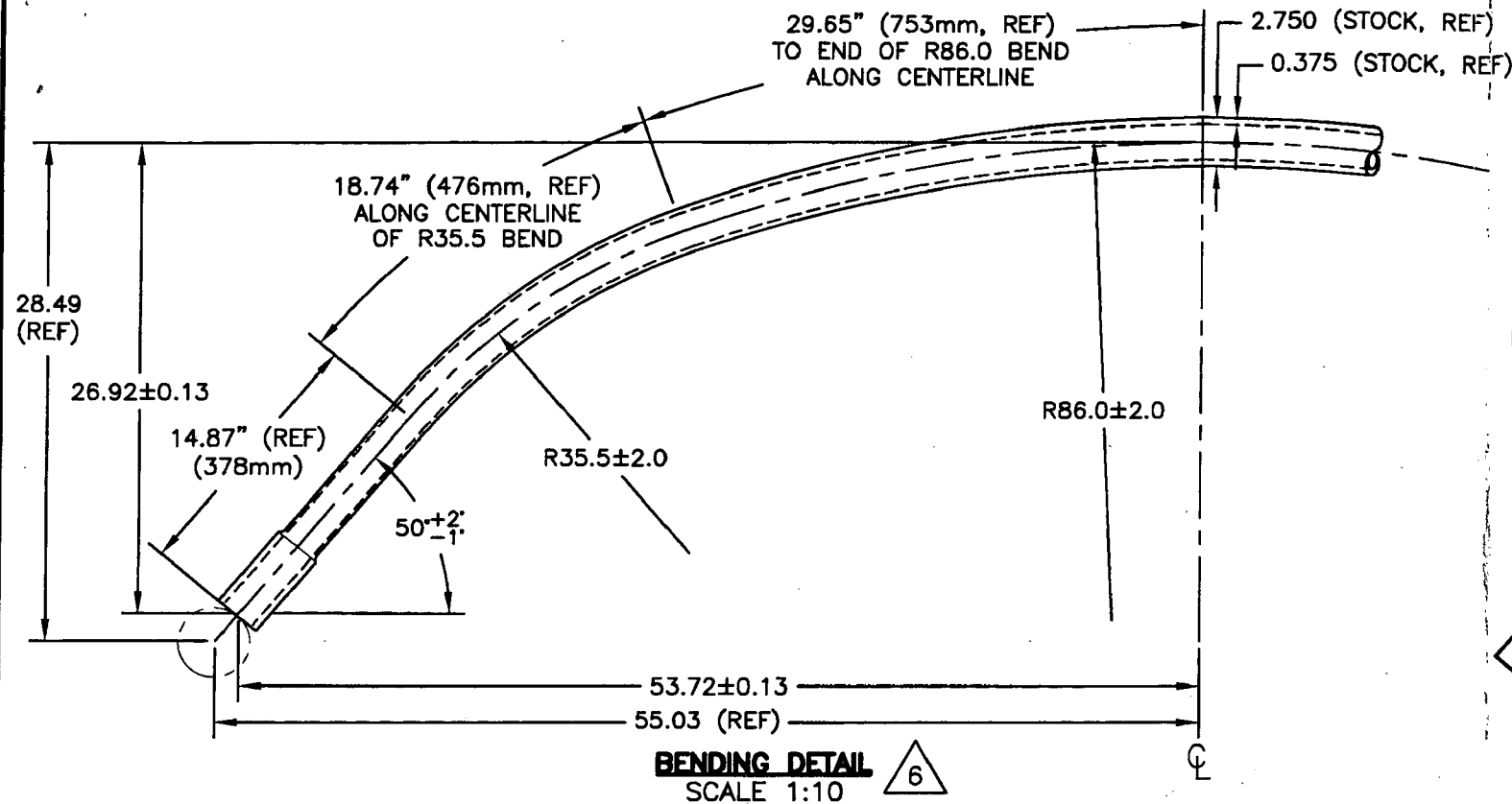
CLIENT REPRESENTATIVE		DTR # E19692	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 <sup>ST</sup> TECHNICIAN	2 <sup>ND</sup> TECHNICIAN	
CGSB LEVEL	2	CGSB LEVEL	SNT LEVEL
CGSB REG. No	6156	CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

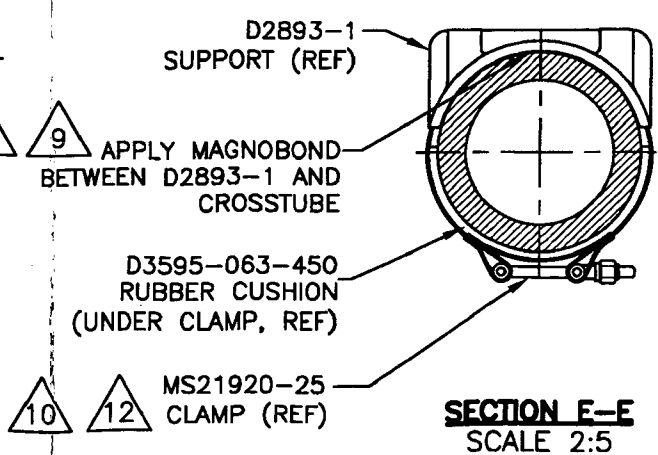
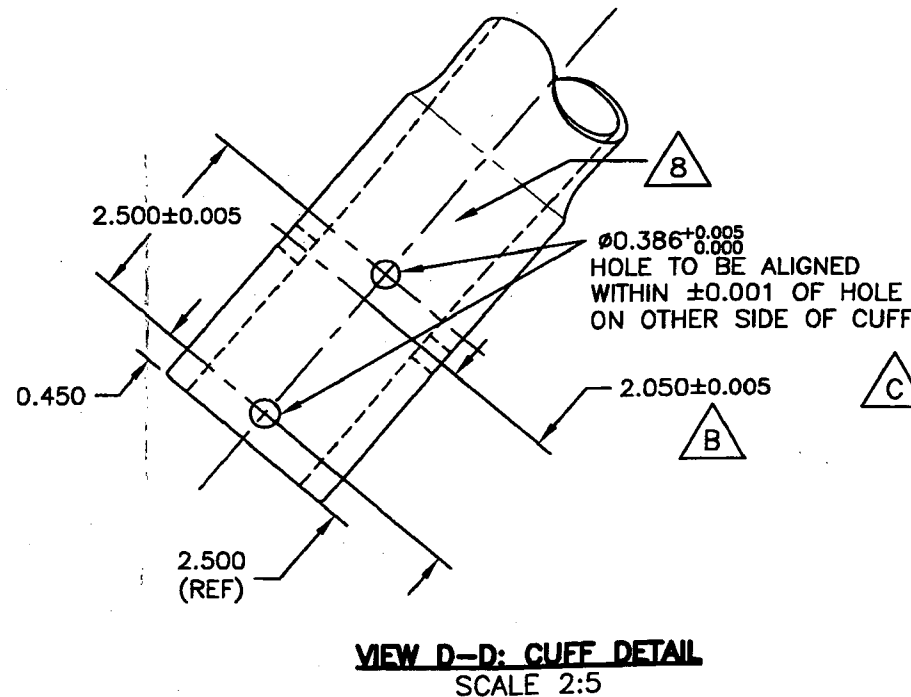
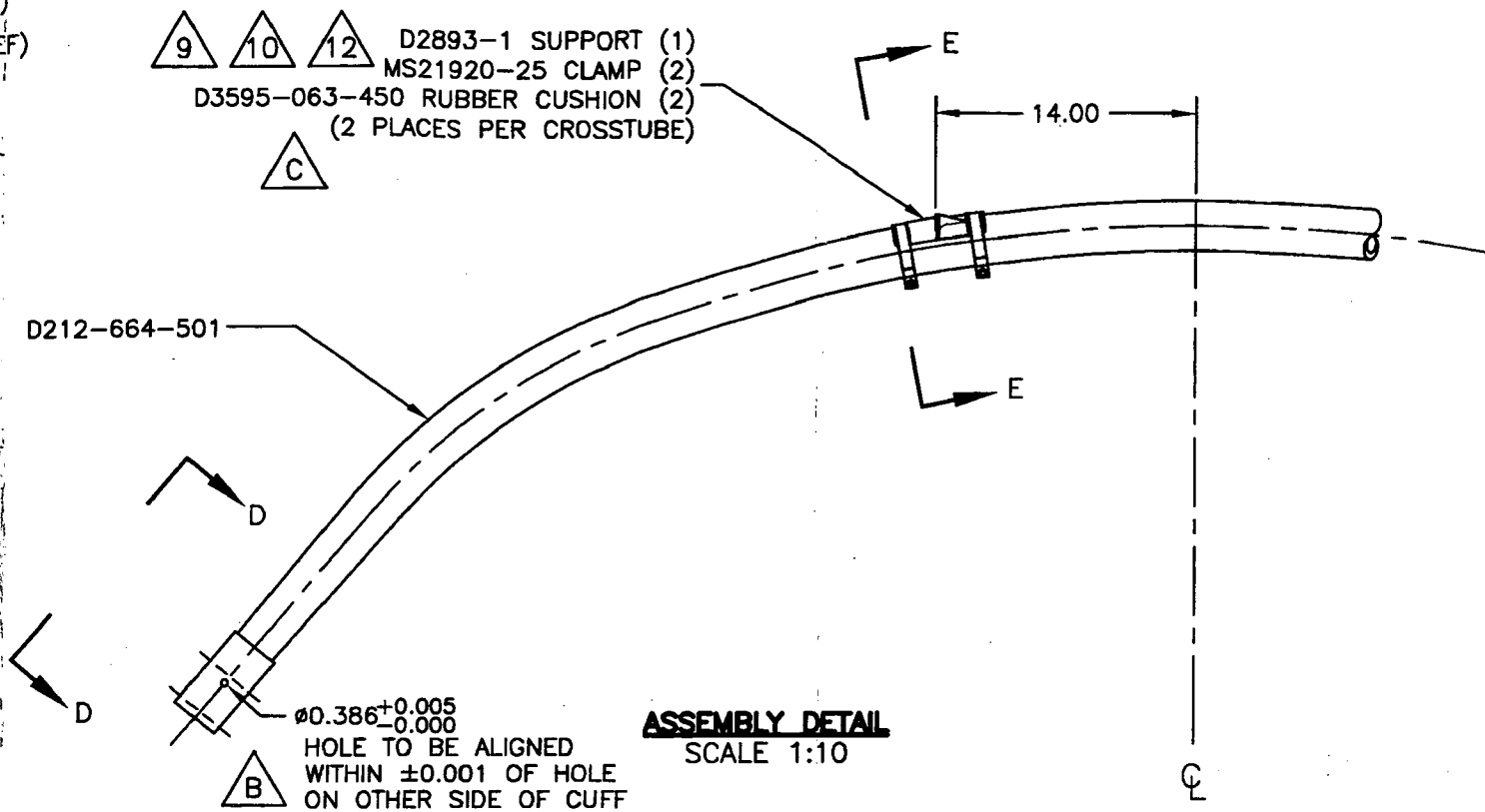
PINK - TECHNICIAN COPY

GOLD - OFFICE COPY



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38572

TAPER UNIFORMLY FROM  
2.701±0.005 THROUGH TO 2.772±0.005  
RUNNING OFF PART



RELEASED  
07.04.24

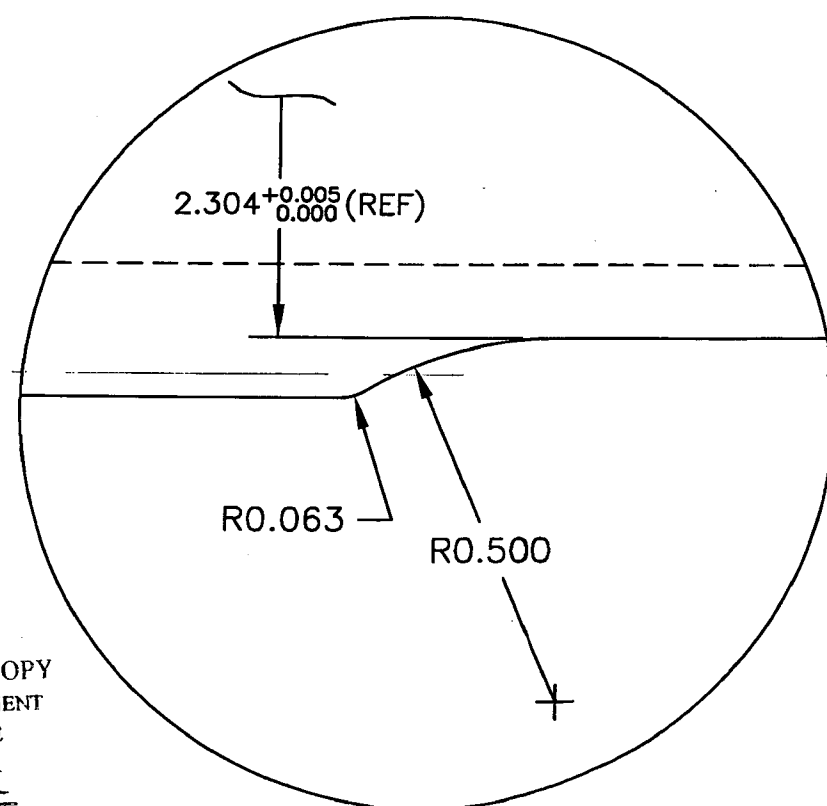
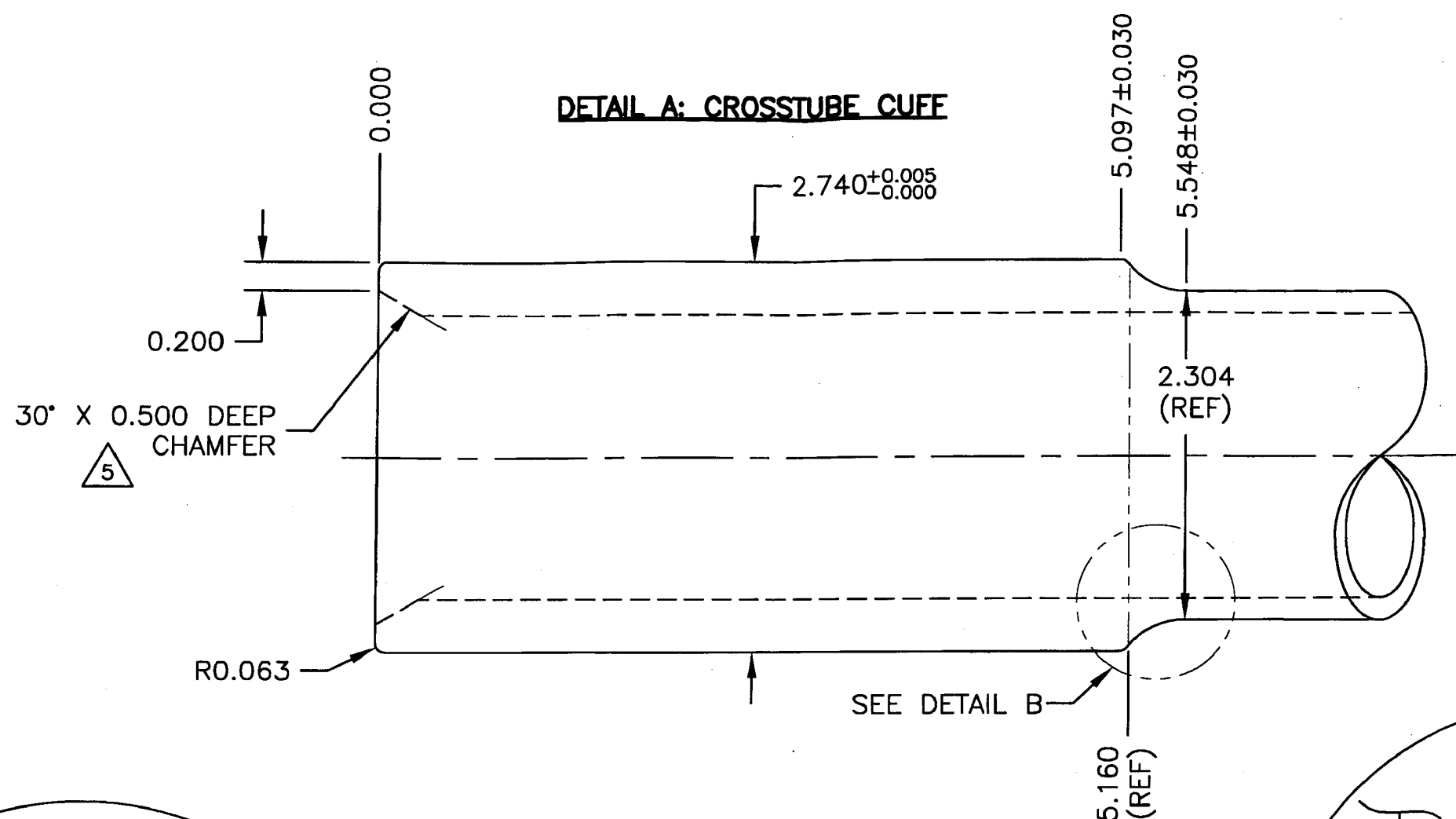
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	GP	APPROVED	H	DRAWING NO.	REV. C
		DATE	07.03.08			D212-664-141	SHEET 2 OF 3
						TITLE	SCALE
						XTUBE ASS'Y (205/212/412 HI FWD)	1:10





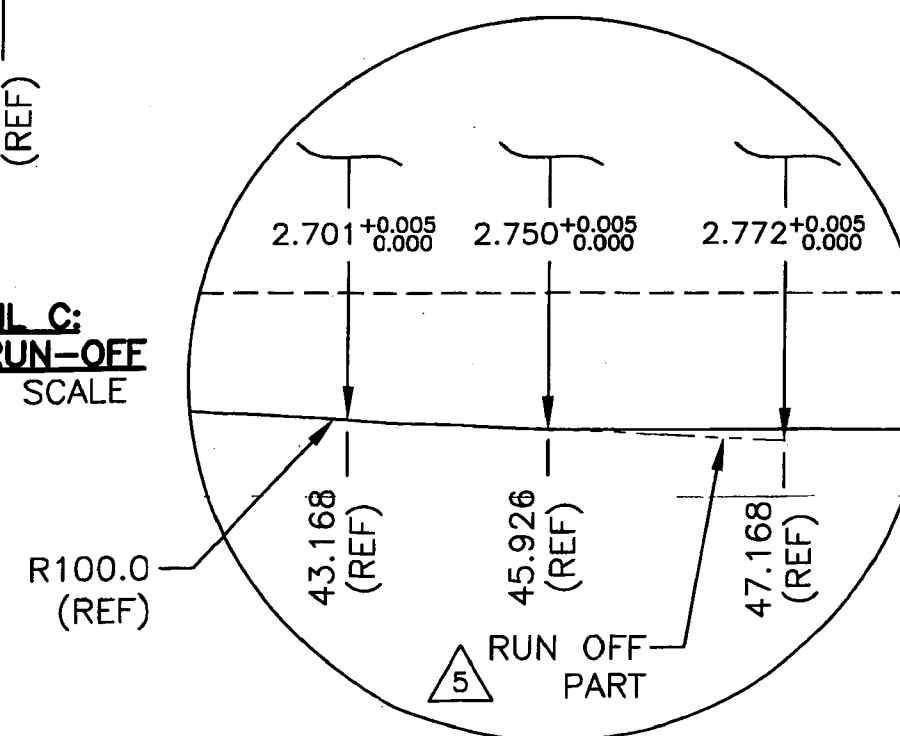
**RELEASED**  
 07.04.24 (P)  
 PER E.L.N. 883

**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
 TRANSITION**  
 SCALE 4:1

**DETAIL C:  
 TAPER RUN-OFF**  
 NOT TO SCALE



SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 38572

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED J	APPROVED J	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08	TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1	

